

ABSTRACT

An apparatus to form bends in a substantially rectangular metal frame. The substantially rectangular metal frame is selectively positioned in an elongated radius bend jig. The elongated radius bend jig has a pivotally
5 connected mandrel that has an inverted J-shaped die formed at one end. The mandrel is actuated and the inverted J-shaped die engages the substantially rectangular metal frame causing an indentation in the substantially rectangular metal frame. The process of die stamping the substantially rectangular metal frame is continued until a selected radius is formed in the
10 frame.